

Slip Dec 5-6

Work Order ID 77212

77212

Page 1

Item ID: D4526-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Maintenance Step Assembly

Start Date: 29/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 13/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/11/29

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4526

A

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

0.00

110

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg
Torque screws up to 15-25 in- lbs

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

EP 11/12/07

EP 11/12/07

VI

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77212

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 29/11/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 13/12/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

u12/7

MF
11-12-01

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

November-29-11 9:52:26 AM

Page 1

Work Order ID: 77212

77212

Parent Item: D4526-042

D4526-042

Parent Item Name: Maintenance Step Assembly

Start Date: 29/11/2011

Required Date: 13/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 *D4092-1* Maintenance Step		Manufactured	No			100	Each	1.0000	2	2		11/12/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				1		B 77189			
					74303			1					
D4526-043 *D4526-043* Tube Assembly		Manufactured	No			100	Each	0.0000	1	1		11/12/06	
D4527-1 *D4527-1* Bracket		Manufactured	No			100	Each	0.0000	1			11/12/06	
D4527-3 *D4527-3* Bracket		Manufactured	No			100	Each	0.0000	1			11/12/06	
MS21042L3 *MS21042L3* Nut		Purchased	No			100	Each	7,932.000	10	10		11/12/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST300				192					
				117441				16					
				117885				35					
				118451				5					
				118927				136					
				ST516				5994					
				119017				5994					
				ST518				1746					
				119075				1746					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

November-29-11 9:52:26 AM

Page 2

Work Order ID: 77212

77212

Parent Item: D4526-042

D4526-042

Parent Item Name: Maintenance Step Assembly

Start Date: 29/11/2011

Required Date: 13/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS24694-S55

Purchased

No

100

Each

81.0000

8

8

MS24694-S55

Screw

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST289A

81

119307

81

MS24694-S75

Purchased

No

100

Each

0.0000

2

2

MS24694-S75

Screw

**

EP 11/12/07

NAS1149D0332J

Purchased

No

100

Each

3,022.000

10

10

NAS1149D0332.I

Washer

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST298

3022

105793

12

110985

4

117087

99

118384

907

119042

1000

119717

1000

10

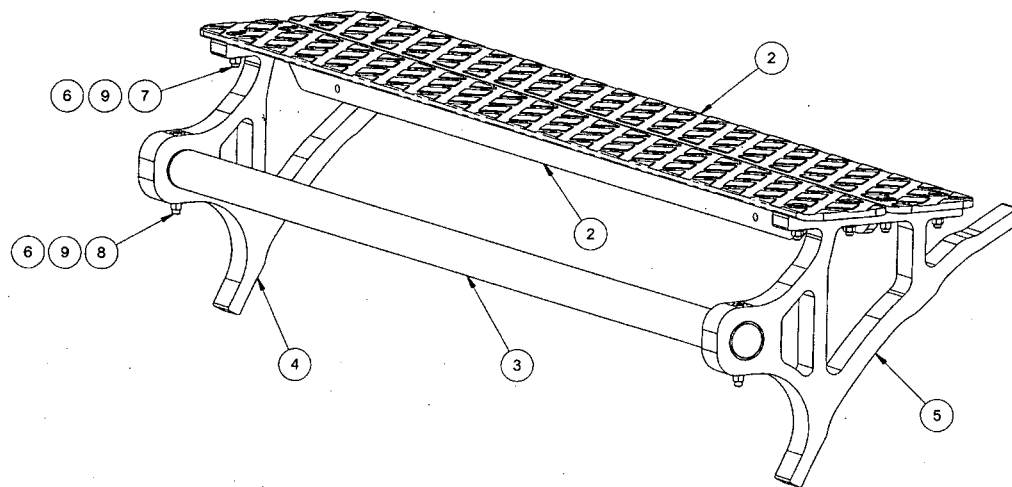
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4526-042 MAINTENANCE STEP ASSEMBLY

ITEM	QTY -042	PART NUMBER	DESCRIPTION
1	X	D4526-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4526-043	TUBE ASSEMBLY
4	1	D4527-1	BRACKET
5	1	D4527-3	BRACKET
6	10	MS21042L3	NUT
7	8	MS24694-S55	SCREW
8	2	MS24694-S75	SCREW
9	10	NAS1149D0332J	WASHER

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 77212 M.C.J
11/11/29

RELEASED
2011-11-28

A	NEW ISSUE	RF	11.11.22
REV.	DESCRIPTION		BY
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	CH	DRAWING NO.	REV. A
MFG. APPR.	CH	D4526	SHEET 1 OF 5
APPROVED	CH	TITLE	SCALE
DE APPR.	CH	MAINTENANCE STEP ASS'Y	NTS
DATE	11.11.22	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

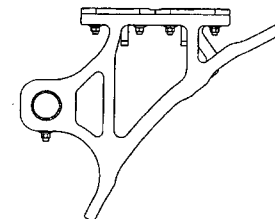
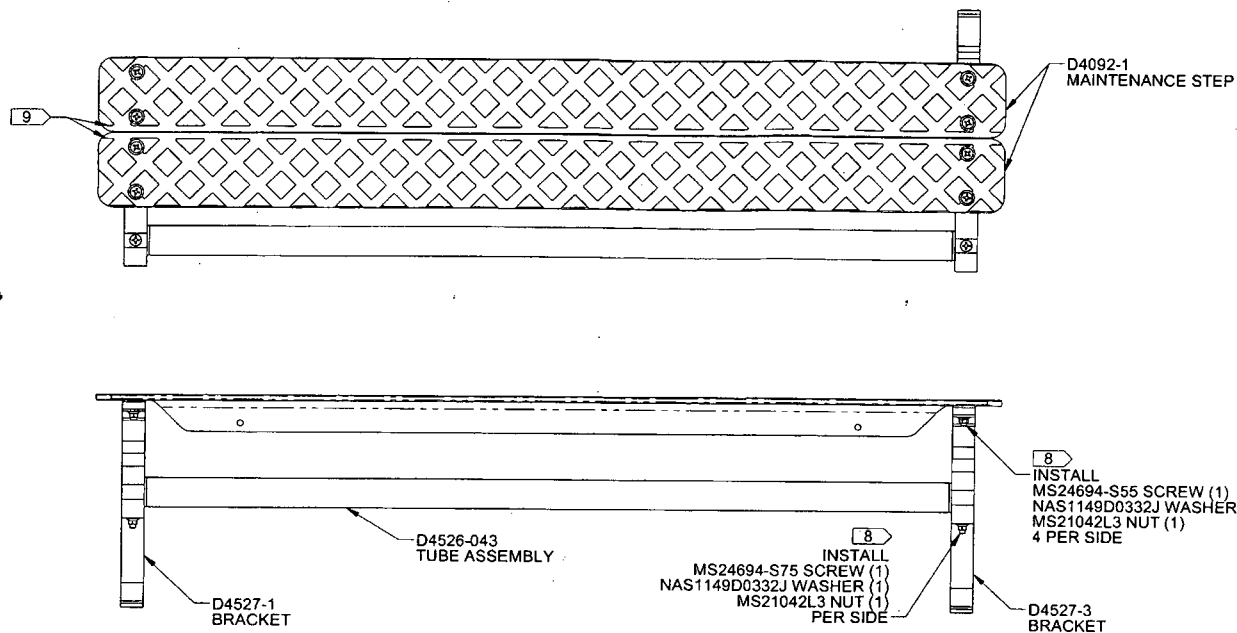
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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D4526-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 7.09 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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2011-11-28

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MFG. APPR.	<i>[Signature]</i>	D4526	SHEET 2 OF 5
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

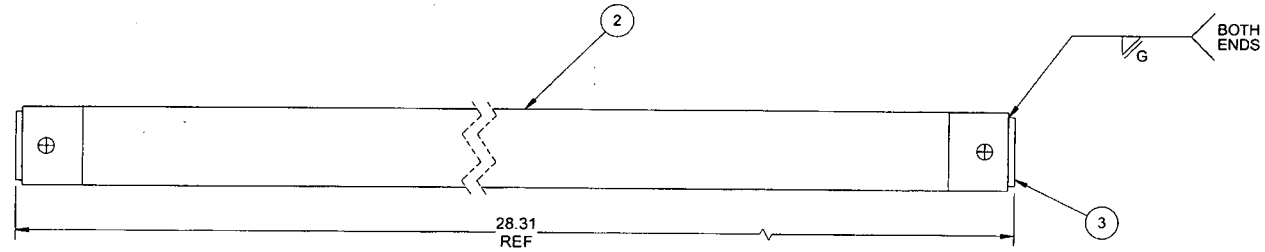
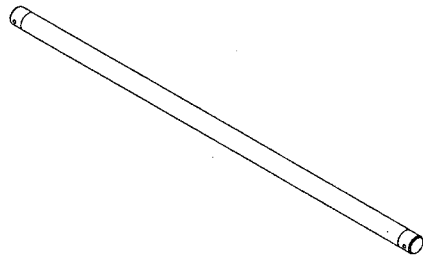
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

77212

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4526-043	TUBE ASSEMBLY
2	1	D4526-1	TUBING
3	2	D4526-3	CAP



D4526-043 TUBE ASSEMBLY

RELEASED
2011-11-28

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER QSI 044 6.1
 - 7) WEIGHT: 1.32 lbs
 - 8) WELD PER QSI 004

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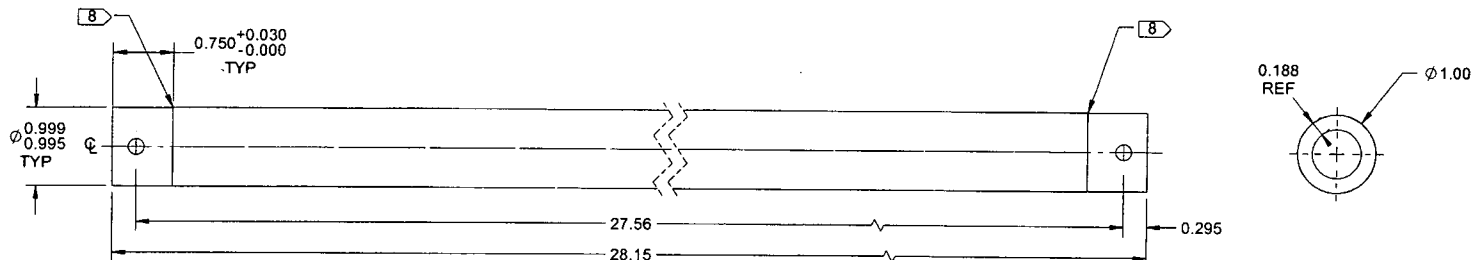
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77212



D4526-1 TUBING

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2011-11-28
NW

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T6T1.000W.188
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs
- 8) MIN RADIUS OF TRANSITION OF R0.06

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MFG. APPR.	<i>[Signature]</i>	D4526	SHEET 4 OF 5
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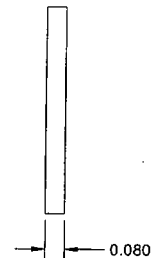
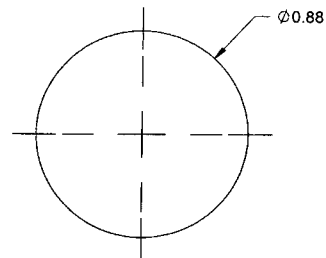
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77212



D4526-3 CAP

RELEASED
R 2011-11-28

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.005 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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